

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

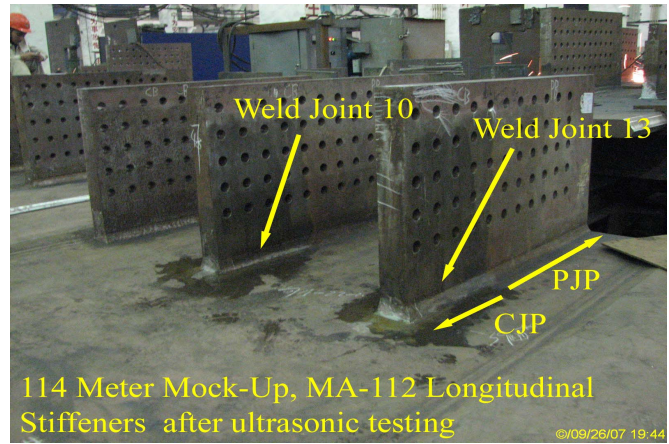
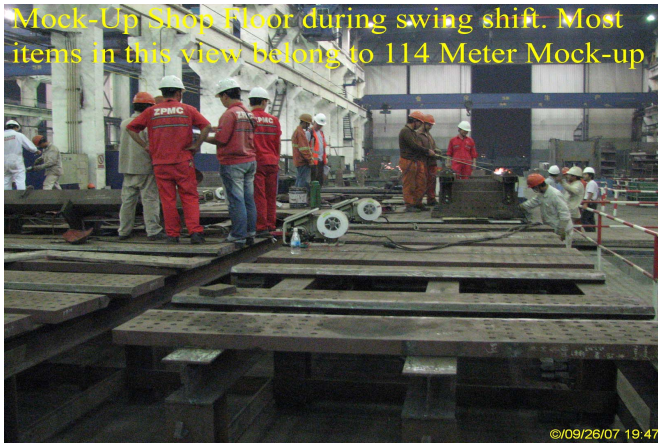
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000563**Date Inspected:** 26-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Bing Xu and Lefeng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 114 Meter Mock-Up**Summary of Items Observed:**

This Quality Assurance Inspector witnessed ultrasonic testing by ZPMC personnel on the 114 Meter Mock-Up, Skin Plate C, MA-101, weld joints 5 and 8 from the C side of the joint. Each complete joint penetration weld was approximately 500 millimeters in length and weld number 8 had a 500 millimeter long indication and weld joint 5 had a 50 millimeter long indication. Ultrasonic testing was also carried out on two repair welds on Face C Skin Plate of MA-112 complete penetration T- joint welds number 10 and 13. Both of these welds also failed ultrasonic testing due to a 48 and 39 millimeter long indications. The ZPMC ultrasonic testing technicians were Li Li Ming and E Shin Qin.

This Quality Assurance Inspector witnessed the tack welding of the longitudinal stiffeners on MUSC-MP-110. by ZPMC welders Guo Dengyun, welder identification 037997. The amperage was found to be 175 with a pre-heat temperature of 152 degrees C. The welding procedure specification being followed was WPS-B-P-2122-TC-U5-b.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No significant conversation held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer